

Work Order ID 61311

August 16, 2010 4:19:08 PM



Page 1

Item ID: D3492-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug Assembly

Start Date: 8/16/10 Start Qty: 60.00



Cust Item ID:

Required Date: 8/20/10 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 10/8/18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3492 | Rev C |

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA633 & Dwg D3492 □ Dwg Rev: C □ Folio
Rev: AA

SL 10/8/18

60

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/8/18

60

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 10/8/18

60

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 61311

August 16, 2010 4:19:08 PM



Page 2

Item ID: D3492-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug Assembly

Start Date: 8/16/10 Start Qty: 60.00



Cust Item ID:

Required Date: 8/20/10 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Small Fab | 0.00 | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | 1-Deburr if neccessary 2-Tumble | | | | | | | | |
| 140 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 150 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |

B10-8-25

8/16/25

eocut
460

8/16/25

X60

9

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 61311

August 16, 2010 4:19:08 PM



Page 4

Item ID: D3492-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug Assembly

Start Date: 8/16/10

Start Qty: 60.00



Cust Item ID:

Required Date: 8/20/10

Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/26 LG

CL10/8/26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

August 16, 2010 4:19:07 PM

Page 1
T

Work Order ID: 61311



Parent Item: D3492-041



Parent Item Name: Plug Assembly

Start Date: 8/16/10

Required Date: 8/20/10

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP rev A 06.03.03 New Issue EC
IPP Rev:B 06-08-28 As per Rev B JLM
IPP Rev:C 07-12-06 Rev C dwg DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|---------------|--|-----------|----|--|--|-----|---|---------|--------|----------|--|--|--|
| M6061T6R0.625 | | Purchased | No | | | 100 | f | 77.5000 | 0.0625 | 3.947368 | | | |
|---------------|--|-----------|----|--|--|-----|---|---------|--------|----------|--|--|--|



6061-T6 Round Bar .625"

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT | 24 | |
| 114415 | 24 | |
| MAT012 | 53.5 | |
| 112697 | 10.5 | |
| 113796 | 43 | |

not in computer / 112611

4.0 52 10/08/18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 61311 |
| Description: Plug | | Part Number: | D3492-1 |
| Inspection Dwg: D3492 Rev: C | | Page 1 of 1 | |



FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

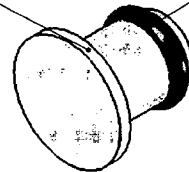
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 0.060 | +/-0.005 | .056 | ✓ | | Vern JL-3 | |
| 0.060 | +/-0.005 | .060 | ✓ | | " | |
| Ø0.394 | +/-0.010 | .395 | ✓ | | " | |
| Ø0.625 | +/-0.010 | .627 | ✓ | | " | |
| 0.090 | +0.000/-0.002 | .089 | ✓ | | " | |
| 0.500 | +/-0.010 | .499 | ✓ | | " | |
| 0.055 | +0.000/-0.002 | .054 | ✓ | | " | |
| 0.050 x 20° | +/-0.010 | .05X20° | ✓ | | " | |
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|---------------------|----------|--------------------|----------|----------------------------|-----|
| Measured by: | JL | Audited by: | DJP | Prototype Approval: | N/A |
| Date: | 10/08/18 | Date: | 10/08/18 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|--|
| A | 06.06.02 | New Issue P/O D3492-041 | KJ/JLM | |
| B | 06.10.16 | Ø0.625 was Ø0.500 | KJ/JLM | |
| C | 07.11.23 | Tolerances revised | KJ/EC/DD | |
| D | 08.06.19 | 0.050 x 20° dimension added | KJ/DD | <div style="display: flex; align-items: center;"> <div style="margin-right: 20px;">  </div> <div>  </div> </div> |

D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61311
C21018114

D3492-XXX PLUG PARTS LIST

| QTY -041 | QTY -043 | QTY -045 | QTY -047 | QTY -049 | QTY -051 | QTY -053 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|
| X | | | | | | | D3492-041 | PLUG ASSEMBLY |
| | X | | | | | | D3492-043 | PLUG ASSEMBLY |
| | | X | | | | | D3492-045 | PLUG ASSEMBLY |
| | | | X | | | | D3492-047 | PLUG ASSEMBLY |
| | | | | X | | | D3492-049 | PLUG ASSEMBLY |
| | | | | | X | | D3492-051 | PLUG ASSEMBLY |
| | | | | | | X | D3492-053 | PLUG ASSEMBLY |
| 1 | | | | | | | D3492-1 | PLUG |
| | 1 | | | | | | D3492-3 | PLUG |
| | | 1 | | | | | D3492-5 | PLUG |
| | | | 1 | | | | D3492-7 | PLUG |
| | | | | 1 | | | D3492-9 | PLUG |
| | | | | | 1 | | D3492-11 | PLUG |
| | | | | | | 1 | D3492-13 | PLUG |
| | | 1 | | | | | NAS1611-005 | O-RING |
| | | | 1 | | | | NAS1611-007 | O-RING |
| 1 | | | | | | | NAS1611-010 | O-RING |
| | | | | | | 1 | NAS1611-012 | O-RING |
| | 1 | | | | | | NAS1611-013 | O-RING |
| | | | | | 1 | | NAS1611-015 | O-RING |
| | | | | 1 | | | NAS1611-016 | O-RING |

△ C △ C △ C

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

~~UNDER REVIEW~~

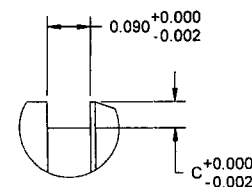
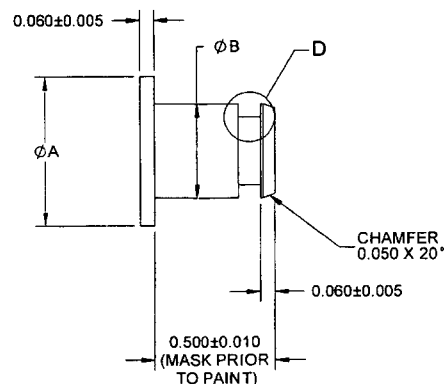
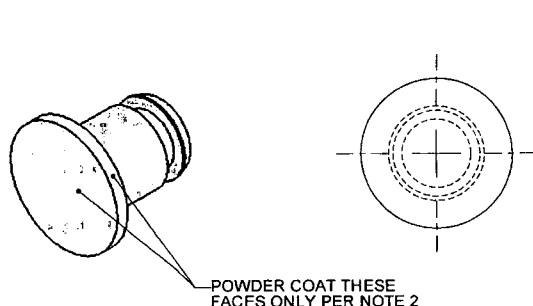
C2.04.2.2
OK ASS 08.11.12

DEO ATTACHED

RELEASED
5.1.16.114

| | | | |
|------------|---|--|--------------|
| C | ADD -049/-051/-053, CHANGE DRAWING FORMAT | PH | 07.10.05 |
| B | ADD -047: UPDATE DIM A FOR -045 | PH | 06.05.11 |
| A | NEW ISSUE | PH | 06.01.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <u>PH</u> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | <u>PH</u> | | |
| CHECKED | <u>PH</u> | DRAWING NO. | REV. C |
| MFG. APPR. | <u>PH</u> | D3492 | SHEET 1 OF 2 |
| APPROVED | <u>PH</u> | TITLE | SCALE |
| DE APPR. | <u>PH</u> | PLUG | 2:1 |
| DATE | 07.10.05 | COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

8 7 6 5 4 3 2 1



DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-1 | 0.625 | 0.394 | 0.055 | M6061T6R0.625 |
| D3492-3 | 0.750 | 0.582 | 0.045 | M6061T6R0.750 |
| D3492-5 | 0.375 | 0.188 | 0.045 | M6061T6R0.375 |
| D3492-7 | 0.500 | 0.270 | 0.045 | M6061T6R0.500 |
| D3492-9 | 0.938 | 0.750 | 0.045 | M6061T6R1.000 |
| D3492-11 | 0.850 | 0.664 | 0.045 | M6061T6R0.875 |
| D3492-13 | 0.750 | 0.520 | 0.045 | M6061T6R0.750 |

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 61311

UNDER REVIEW

01.07.11
DEM. 10 ON D3492-13
REF. 12 (HOLE SMALLER)
11.12
OK

DEO ATTACHED

RELEASED
07.11.16

| | | | |
|---|-----------|--|--------------|
| DESIGN | <i>RA</i> | DART AEROSPACE LTD | |
| DRAWN | <i>RA</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>RA</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>RA</i> | D3492 | SHEET 2 OF 2 |
| APPROVED | <i>RA</i> | TITLE | SCALE |
| DE APPR. | <i>RA</i> | PLUG | 4: |
| DATE | 07.10.05 | COPYRIGHT © 2007 BY DART AEROSPACE LTD | |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | | | |

8 7 6 5 4 3 2 1

| | | | | | | | |
|----------------------|------------------|------------------|---|--|-------------------------|---------------------------|--------------|
| DRAWING NO. D3492 | TITLE PLUG | REV. C | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3492-C-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN AJS | CHECKED | MFG. APPR. | APPROVED | | DE APPR. | | |
| DATE 08.11.05 | DATE 08.11.05 | DATE 08.11.05 | DATE 08/11/05 | | DATE 08/11/05 | | |

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-13 | 0.750 | 0.510 | 0.045 | M6061T6R0.750 |

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WORK ORDER
NO. 61311

WAS:

D3492-XX PLUG MACHINING DETAILS

| P/N | A | B | C | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-13 | 0.750 | 0.520 | 0.045 | M6061T6R0.750 |

RELEASED
08/11/10